

SPLIT - ship today
06/02

DUPLICATE

Work Order ID 112586-2

112586

Monday, February 03, 2014 9:21:57 AM

Item ID: D4072-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: ① 12.00 Stop *NS2*
 Item Name: Airframe Hinge
 Start Date: 1/31/2014 Start Qty: 12.00 ~~24.00~~ *12* Cust Item ID:
 Required Date: 2/5/2014 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: mur Date: 14-2-3 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4072	B								
100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT 1.250" LONG								
105		0.00							
105									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Mill as per Dwg an Folio FA938								
	Dwg Rev: <u>B</u>								
	Folio Rev: <u>AA</u>								
	Deburr								

12 ~~8~~ 14/02/05

14-02-06

Work Order ID 112586

Monday, February 03, 2014 9:21:57 AM

112586

Page 2

Item ID: D4072-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Airframe Hinge
 Start Date: 1/31/2014 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 2/5/2014 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00							

14-02-06

14/02/06

1 0

1 14-2-6

Work Order ID 112586

Monday, February 03, 2014 9:21:57 AM

112586

Page 3

Item ID: D4072-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Airframe Hinge
 Start Date: 1/31/2014 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 2/5/2014 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M126837</i> Memo <i>START: 2:15</i> <i>OVER T: 300°</i> <i>FINISH 2:45</i>	0.00				<i>1</i>	<i>0</i>	<i>14-2-6</i>	<i>DAS 34 9-08</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>14/2/6</i>		<i>1</i>			
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>ship</i>	0.00 0.00				<i>1X</i>		<i>14-02-6</i>	<i>DAS 28 9-08</i>

033
34
1/2

Work Order ID 112586

Monday, February 03, 2014 9:21:57 AM

112586

Page 4

Item ID: D4072-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Airframe Hinge
 Start Date: 1/31/2014 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 2/5/2014 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

PL 14-02-6
 MRF
 14-2-6



Picklist Print

Monday, February 03, 2014 9:21:57 AM

Page 1

Work Order ID: 112586

Parent Item: D4072-1

Start Date: 1/31/2014

Required Date: 2/5/2014

Parent Item Name: Airframe Hinge

Start Qty: 12.00

Required Qty: 12.00

Comments: Ipp Rev:A New Issue 10-06-09 JLM Verified By:DD IPP REV:B DRAWING REV.
CHANGE AS PER ECN 11-598 11-07-05 JFS VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.500 6061-T6 Bar 1.00 x 2.50		Purchased	No			100	f	9.0500	0.104	2			

Location

Loc Qty

Loc Code

MAT003

9.05

124443

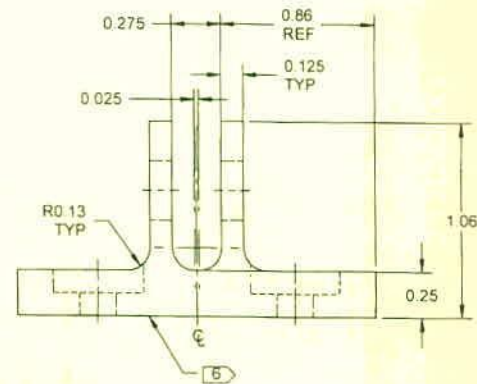
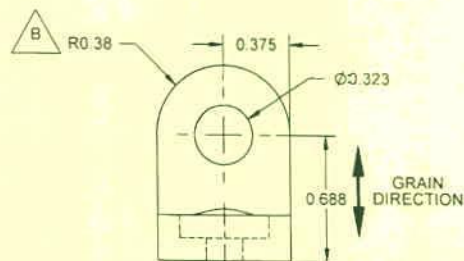
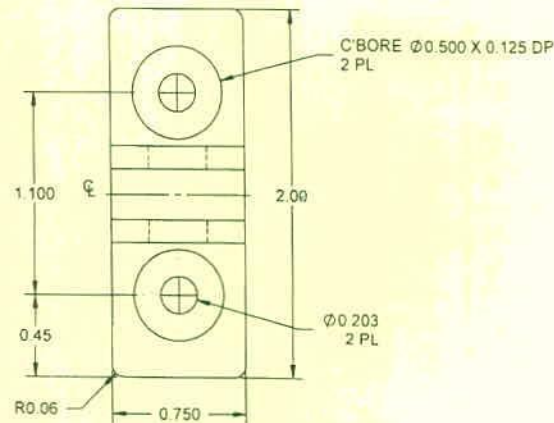
8.25

125386

0.8

1,3

14/02/05



D4072-1 AIRFRAME HINGE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMD 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

RELEASED
2011-06-30
AM

B	CORRECT TYPO (ZN B7-1)	RF	10.11.02
A	NEW ISSUE	RF	10.09.15
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	RF		
CHECKED			
MFG APPR			
APPROVED			
DE APPR			
DATE	10.11.02		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

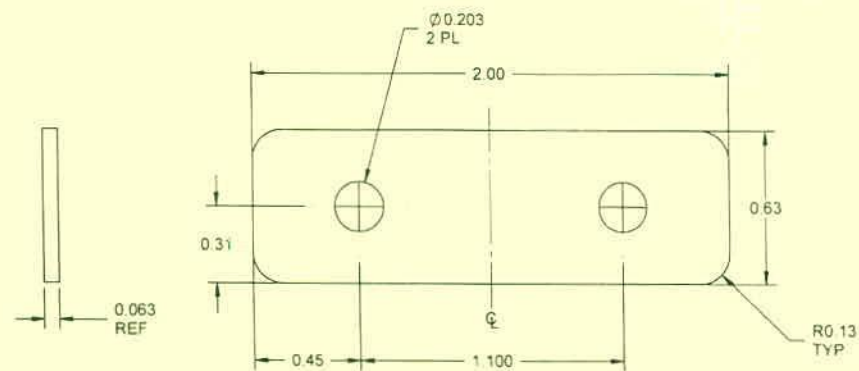
DRAWING NO.
D4072

TITLE
AIRFRAME HINGE

SCALE
N'S

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REV. B
SHEET 1 OF 3



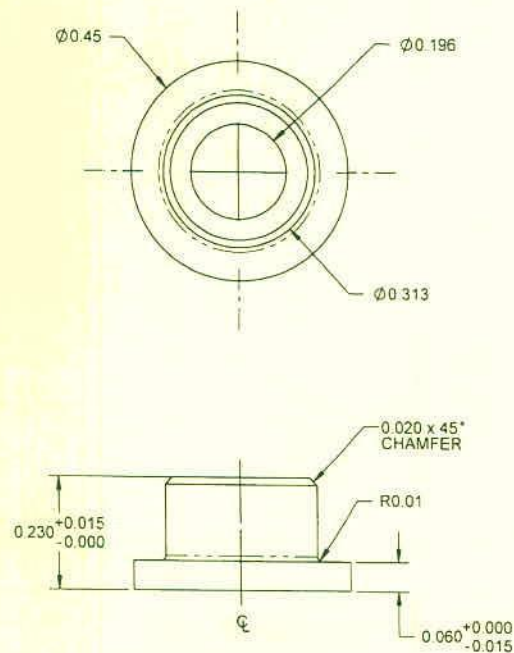
D4072-3 AIRFRAME HINGE BACKING PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3 5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: PER QSI 044 5.1
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG APPR	RF	D4072	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR	RF	AIRFRAME HINGE	N'S
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RELEASED
2011-06-30



D4072-5 BUSHING



NOTES

- 1) MATERIAL: AISI 303 STAINLESS STEEL BAR
REF DART SPEC. M303B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.004 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO	REV. B
MFG. APPR.	<i>[Signature]</i>	D4072	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AIRFRAME HINGE	NTS
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RELEASED
2011-06-30

DART AEROSPACE LTD		Work Order: 112586
Description: Airframe Hinge		Part Number: D4072-1
Inspection Dwg: D4072	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500 x 0.125	+/-0.010	0.500 x 0.125	✓		vern	45-4
2.00	+/-0.030	2.00	✓			
Ø0.203	+0.005/-0.001	0.206	✓			
0.750	+/-0.010	0.748	✓			
R0.06	+/-0.030	0.060	✓			
0.45	+/-0.030	0.446	✓			
1.100	+/-0.010	1.100	✓			
R0.38	+/-0.030	0.370	✓			
0.375	+/-0.010	0.374	✓			
0.688	+/-0.010	0.685	✓			
0.275	+/-0.010	0.275	✓			
R0.13	+/-0.030	0.130	✓			
0.25	+/-0.030	0.256	✓			
1.06	+/-0.030	1.060	✓			
0.125	+/-0.010	0.125	✓			
0.86	+/-0.030	0.866	✓			
Ø0.323	+0.005/-0.001	0.324	✓			

Measured by: ST	Audited by: [Signature]	Preliminary Approval:
Date: 14-02-06	Date: 14/02/06	Date:

Rev	Date	Change	Revised by	Approved
A	11.06.26	New Issue	KJ	[Signature]
B	11.10.13	Dimension 0.25 removed	KJ	[Signature]

